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D4930-1
Job Sheet 197795



Part No: D4930-1

Job Qty: 4 pcs

Part Name: Bearpaw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/16/19

Job Tracking No:

Due Date: 7/31/19

Created By: Jason Leroux

Type: Stock

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 13-10-07 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	4 pcs	7/31/19	7/31/19	0.17	0.88	Waterjet - Flow		DL 19/07/17
120	HAAS 4 Axis - B4B	4 pcs	7/31/19	7/31/19	0.75	4.82	HAAS - 4 - B4B		DD 19-07-24
140	QC 8	4 pcs	7/31/19	7/31/19	0.00	0.00	QC 8 - 12		DL 19/07/25
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
150	Packaging 3-1 - Stock - B4B	4 pcs	7/31/19	7/31/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		

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				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC ST-159
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	4 pcs	7/31/19	0.00 0.00	QC 21 - SA - 21	JUL 26 2019
				QC 21 - SA - 70	71/ DAS 70
				QC 21 - SA - 53	9-89

Part Op 110 - CUT BLANK AS PER FILE D4930-1 BLANK

Descriptions: 120 - (HAAS CNC Vertical Machine) 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FB217 and Dwg

140 - (QC8- Inspect parts - second check)

150 - (Identify as per dwg & Stock Location: _____)

160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	5.0600 sf (1.265 ea)	110-Waterjet - Flow - 1	3045597

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	MUHMWB10	5	878	0

D4930-1

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	12.140Inches $\pm$ 0.030	12.170 12.110	12.140	
2	Bearpaw	12.760Inches $\pm$ 0.030	12.790 12.730	12.750	
3	Bearpaw	0.380Inches $\pm$ 0.030	0.410 0.350	0.380	
4	Bearpaw	1.880Inches $\pm$ 0.030	1.910 1.850	1.875	
5	Bearpaw	1.190Inches $\pm$ 0.030	1.220 1.160	1.200	
6	Bearpaw	0.260Inches + 0.006 - 0.001	0.266 0.259	0.260	Diameter
7	Bearpaw	0.880Inches + 0.010 - 0.001	0.890 0.879	0.880	Diameter
8	Bearpaw	0.450Inches $\pm$ 0.030	0.480 0.420	0.445	
9	Bearpaw	3.850Inches $\pm$ 0.010	3.860 3.840	3.850	
10	Bearpaw	5.870Inches $\pm$ 0.010	5.880 5.860	5.870	
11	Bearpaw	4.250Inches $\pm$ 0.010	4.260 4.240	4.250	
12	Bearpaw	0.070Inches $\pm$ 0.030	0.100 0.040	0.070	
13	Bearpaw	45.000Degrees $\pm$ 0.500	45.500 44.500	45°	Angle
14	Bearpaw	0.250Inches $\pm$ 0.030	0.280 0.220	0.240	
15	Bearpaw	0.630Inches $\pm$ 0.030	0.660 0.600	0.625	
16	Bearpaw	0.950Inches $\pm$ 0.030	0.980 0.920	0.963	
17	Bearpaw	0.130Inches $\pm$ 0.030	0.160 0.100	0.130	
18	Bearpaw	45.000Degrees $\pm$ 0.500	45.500 44.500	45°	Angle
19	Bearpaw	0.525Inches $\pm$ 0.010	0.535 0.515	0.520	
20	Bearpaw	0.375Inches $\pm$ 0.010	0.385 0.365	0.383	
21	Bearpaw	1.143Inches $\pm$ 0.010	1.153 1.133	1.143	

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AEROSPACE

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Container No: S198663

Part: D4930-1

Job No: 197795

Serial No/Batch: S198663

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/17/19